



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71057**

Tuesday, June 21, 2011 1:31:42 PM



Page 2

Item ID: D2939-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH In, 206

Start Date: 6/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00 1 ?				4	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4	0	BL 11-7-11	
155  SprayPaint Spray Painting	  Memo PRIME B 117319 DELFLEET BLUE B 115985 DELFLEET CLEAR B 117113	0.00  0.00				M	11	07	13 (4)

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Tuesday, June 21, 2011 1:31:42 PM



Page 3

Item ID: D2939-2

Accept



Setup Start



Revision ID:

Stop



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Start Date: 6/21/2011 Start Qty: 4.00



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Required Date: 7/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

BT 11-07-14 (x4)

170

Identify as per dwg &amp; Stock Location: 474

0.00



Packaging

Memo

0.00

Packaging

11/7/15 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/15 (4)  
MF  
11-07-15

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 1:31:48 PM

Page 1

Work Order ID: 71057

Parent Item: D2939-2

Parent Item Name: Saddle RH In, 206



Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	49.0000	1	4			
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Saddle Billet



29 11.7.8

Location	Loc Qty	Loc Code
MAT040	44	
64777	20	
66965	4	
69677	20	
MAT40	5	
69700	5	

70975

4

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	71057
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b>	D2939-2
<b>Inspection Dwg:</b> D2939 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.124	.120	.119	.120	
B	0.100	0.140		.131	.120	.119	.119	
C	0.100	0.140		.113	.108	.108	.110	
D	0.210	0.230		.220	.220	.220	.219	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.511	.511	.511	.511	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.257	.257	.257	.257	
L	0.312	0.317	.313	.238	.313	.313	.313	
M	0.235	0.240		.238	.237	.237	.237	
N	0.100	0.140		.110	.109	.109	.109	
O	0.540	0.560		.551	.551	.551	.550	
P	0.490	0.510		.501	.498	.498	.497	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.720	2.760		2.740	2.740	2.740	2.740	
S	0.240	0.270		.250	.250	.249	.250	
T	0.100	0.180		.130	.130	.130	.130	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.250	1.270		1.260	1.261	1.262	1.261	
Y	1.565	1.585		1.575	1.576	1.577	1.576	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
Accept/Reject								

<b>Measured by:</b> RF/JL	<b>Date:</b> 11.7.8
<b>Audited by:</b> CMZ	<b>Date:</b> 11/07/11
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

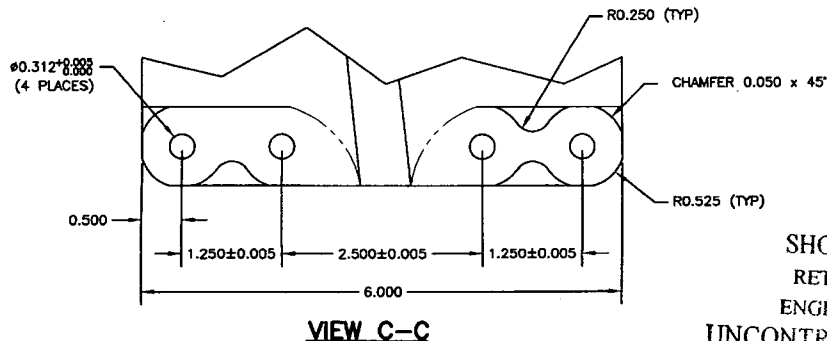
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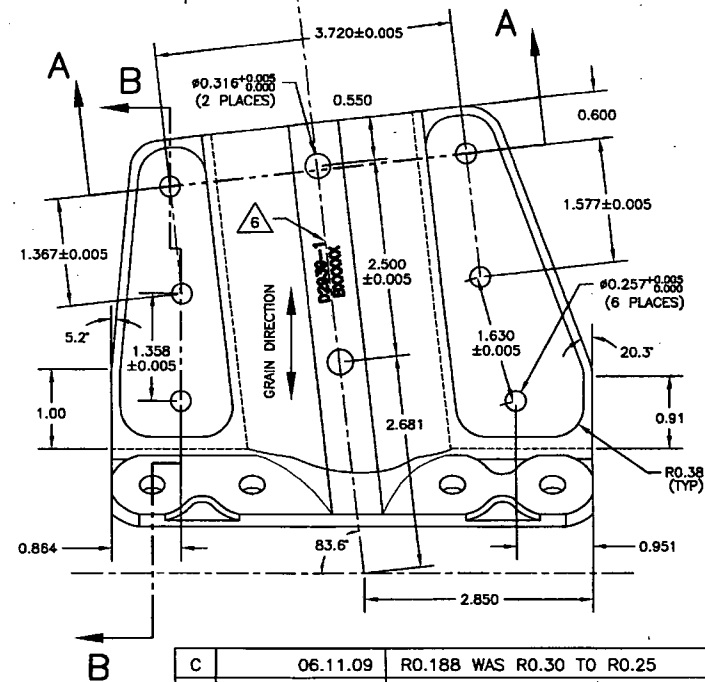
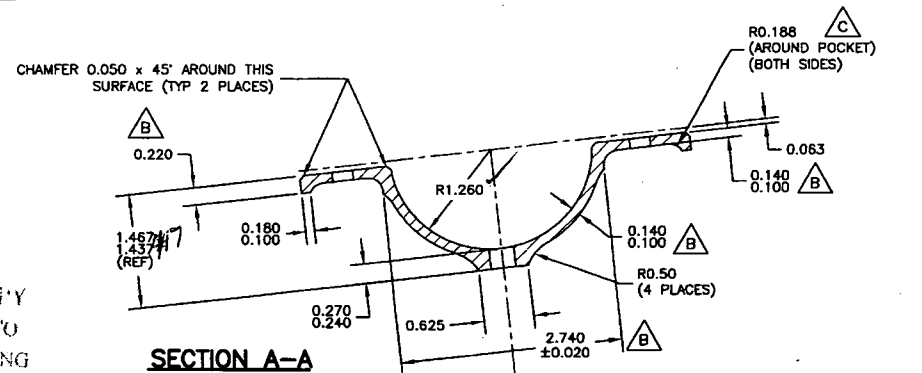
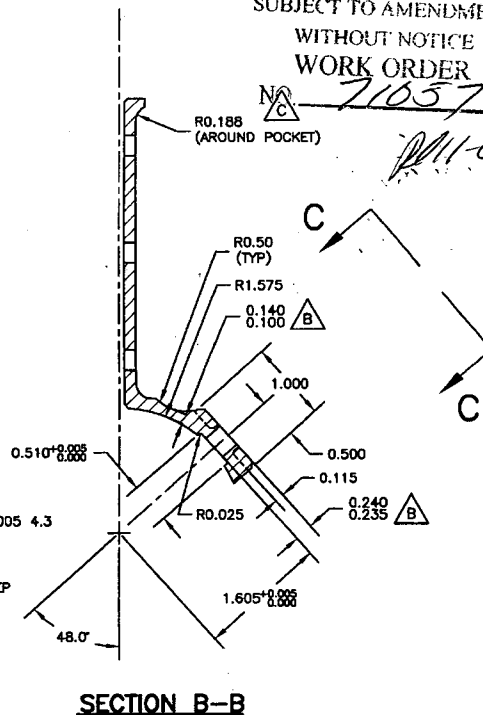
**NOTE:** Date & initial all entries



**D2939-1 LH SADDLE (SHOWN)**  
**D2939-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE

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 DART AEROSPACE USA, INC.

REV. C  
 SHEET 1 OF 1  
 SCALE 2:3

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